June-22-12 1:56:00 PM

Revision ID:	D2275 Bushing		e og til stoffensende og ti	Accept	*N900	04010 0)* s	etup Star Stop	IVI	S1* S2*
Start Date: Required Date: Reference:	22/06/2012 06/07/2012	Start Qty: 20.00 Req'd Qty: 20.00	*20* *20*		Cust Item I Customer:	D:			10	. 7/
Approvals:		n: MLJ	,	Tooling: SPC (Y/N):		nte:	R	tun Star Stop	1/1	R1* R2*
Sequence ID/ Work Center ID)	Operation Description		Set Up/ Run Hours	Tool ID	Tool # Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr								
D2275	Rev	С			15.					
100 *1 Hardinge		Hardinge CNC LATHE S	MALL	0.00	12-1	2.30	20	ф		04
Hardinge CNC Lathe	Small		er Folio FA 213 burr all sharp edges	0.00	,					
110		QC2- Inspect parts off ma	chine FAI/FAIB	0.00			.			(04 (04
110 QC Quality Control		Memo	4 - *	0.00	12. (2	2.36	20	4		9-89
120		QC8- Inspect parts - secon	nd check	0.00						
120 QC Quality Control		Memo		0.00	Je	1 13	01.0	2	20	

Dart Aerospace L	_td^
------------------	------

1446								-	
W/O:			WO	RK ORDER CHANGI	ES				
DATE	STEP	PR	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
					-				
Part No		PAR #:	Fault Categ	ory:	NCR: Yes	No DQ	A:	_ Date: _	
	Res	solution:	Disposition	:	_ QA: N/C Clo	sed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR)			
DATE	STEP	Description of NC		Corrective Action Section		Verific	ation	Approval	Approval
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section	on C	Chief Eng	QC Inspector
	÷								
									
40									
					1				

QC

Quality Control

June-22-12 1:56:00 PM Item ID: D2275 Accept *N900040100* Setup Start **Revision ID:** Item Name: Bushing Start Qty: 20.00 *20* Start Date: 22/06/2012 **Cust Item ID: Required Date:** 06/07/2012 Req'd Qty: 20.00 **Customer:** Reference: Run Approvals: Date: Tooling: Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Accept Reject Insp. **Work Center ID** Description **Run Hours** Qty Qty Number Code Stamp Identify as per dwg & Stock Location: 130 0.00 *130* Packaging 0.00 Memo Packaging *** STOCK IN STEP CELL*** 140 QC21- Final Inspection - Work Order Release 0.00

0.00

Memo

U 13-01.03

W/O:			WO	RK ORDER CHANG	GES				
DATE	STEP	PR	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
·				-					
Part No	•	PAR #:	Fault Categ	ory:	NCR: Yes	No DQ	A:	Date: _	
	Reso	olution:	Disposition	•	QA: N/C CI	osed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NCF	()			
DATE	STEP De	Description of NC			ction B	Verific	cation	Approval	Approval
DAIL	JILI	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Sect	ion C	Chief Eng	QC inspector
		,							

Picklist Print

June-22-12 1:56:03 PM

Work Order ID: 86195

D2275

Parent Item Name: Bushing

86195

D2275

Start Date: 22/06/2012

Required Date: 06/07/2012

Page 1

Start Qty: 20.00

Required Qty: 20.00

Comments:

Parent Item:

IPP E02.03.27Added in house machiningNG

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R1.250		Purchased	No			100	f	25.6600	0.1667	3.509474			
*NACOCATA	SP1 250	*							**				

M6061T6R1 250

Location	Loc Qty	Loc Code	12. (2. 30	$\sim \Lambda \sim$
MAT013 113457	25.66 5.66			04
113550	20		1,833	(5-0-

	Johnson									
W/O:			WO	RK ORDER CHANGE	ES					
DATE	STEP	PRO	CEDURE CHAN	IGE	E	у	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Categ	ory:	NCR:	Yes N	o DQA	\:	Date:	
	Resolution:									
NCR:		V	WORK ORDE	R NON-CONFORMA	NCE (NCR)				
DATE	CTED	Description of NC		Corrective Action Section			Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		ign & Date	Section		Chief Eng	QC Inspector
									-	

		*								

DART AEROSPACE LTD	Work Order:	86195
Description: Bushing	Part Number:	D2275
Inspection Dwg: D2275 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

	FIRST	ARTICLE II	NSPECTI	ON CH	ECKLIST		
	X	First Arti	cle	Prot	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection		mments
1.975	+/-0.010	1.982	-		82, 2		
1.500	+/-0.010	1.508					
Ø0.750	+0.008/-0.001	. 756					
0.10 x 45°	+0.030 x 0.5°	(10					
Ø0.257	+0.006/-0.001	,258					
1.25	+/-0.030	1-2/3					
			-				
Measured by:		Audited by:			Prototype A	Approval:	N/A
Date:	2.2.33	Date:	70	0>	7	Date:	N/A
Rev Date A 06.09.19	Change New Issue					Revised by KJ/JLM	Approved

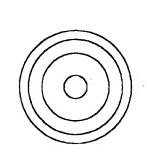
			4											
W/O:			WORK ORDER CHANGES											
DATE	STEP	PRO	OCEDURE CHAN	IGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
10		•												
							4	12.4		-				
		*	•					8						
Part No	:	PAR #:	Fault Categ	ory:		NCR: Yes	No DQA	\:	_ Date: _					
	Resolution:		Disposition	• 5	(A: N/C	Closed:		Date: _					
NCR:			WORK ORDE	R NON-CON	FORMAN	CE (NC	R)		· ·					
DATE	STEP	Description of NC	Corrective Action Sec				Verific	ation	Approval	Approval				
DAIL	OIL!	Section A	Initial Chief Eng	Action Des Chief E		Sign Dat		on C	Chief Eng	QC Inspector				
				*		×			3					
*)														
										,				
				en de la Maria de Maria de Maria de Maria de La Companya de La Com						422				
									*	ŧ				
						* + =								

H:\ff'ORMS\Quality Assurance\approved QA\NCRWO RevE





		_		_		,	
DART AERO ACCESSORIES INC	VICTORIA INTERNATIONAL AIRPORT, CANADA	REV. C	D2275 SHEET 1 OF 1	TITLE	BUSHING 1:1	Nov. 15, 1994 C'BORE WAS COUNTER SINK	96.09.12 C'BORE WAS 0.300 DEEP
PREPARED	B. Williams	KEON APPROVED			Sep. 29, 1994	Nov. 15, 1994	96.09.12
F.	æ	品	0	DATE	Sep	В	ပ



SHOP COPY **RETURN TO**

ENGINEERING

C'BORE

DNTROLL.

JECT TO AMENDME..

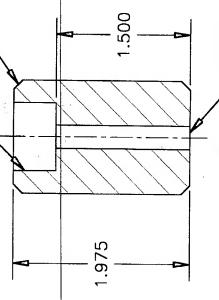
WITHOUT NOTICE

WORK ORDER

NO. 86 195 MCJ

12/06/22 09

X



DIA 0.257 DRILL THROUGH

BAR STOCK 25 6061-MATERIAL:

Copyright 1994 by DART AERO ACCESSORIES INC

	oopaoc	Liu		*						
W/O:			W	ORK ORI	DER CHANGE	S		****		
DATE	STEP	PR	ROCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								3		
÷										
Part No	•	PAR #:	Fault Cat	egory:		NCR: Yes	s No DQA	:	_ Date: _	
	R	esolution:	Dispositi	on: <u>'</u>	· · · · · · · · · · · · · · · · · · ·	QA: NC	Closed:		Date: _	
NCR:		WORK ORE	DER NON	-CONFORMAI	NCE (NC	R)			ı	
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action	e Action Section On Description Chief Eng	B Sigr			Approval Chief Eng	Approval QC Inspector
				*				. J.	(4)	, , ,
				, k	•	4 1 . 4 1 .				
		,								·

^{* &#}x27;H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE